

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027478**Date Inspected:** 21-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** On Site**CWI Name:** Steve Jensen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG Components**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations were:

Segment 12E between PP109 and PP109.5 E5 Line - Deck Access Hole LS East and West:

This QA Inspector observed ABF welder Todd Jackson performing the grinding operation to finish the (2) two completed welds to a flush contour on the complete-joint penetration (CJP) butt-joint groove weld connecting the Deck Access Hole (DAH) insert plate Longitudinal Stiffener (LS) East and (LS) West to the Deck "A" plate LS 6 between panel point PP109 and PP109.5 along Grid line E5.

This QA Inspector observed ABF welder Todd Jackson was still in-process on the grinding operation at the end of this QA Inspectors' shift.

Segment 6E between PP46.5 and PP47 E5 Line - Deck Access Hole:

This QA Inspector observed ABF welder Mike Jimenez (Welder ID 4671) performing the fill and cover pass weld operation of a complete-joint penetration groove weld per the Shielded Metal Arc Welding (SMAW) process in the (4G) overhead position on the Deck Access Hole (DAH) insert plate welded to the Deck "A" plate between panel point PP46.5 and PP47 along Grid Line E5.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

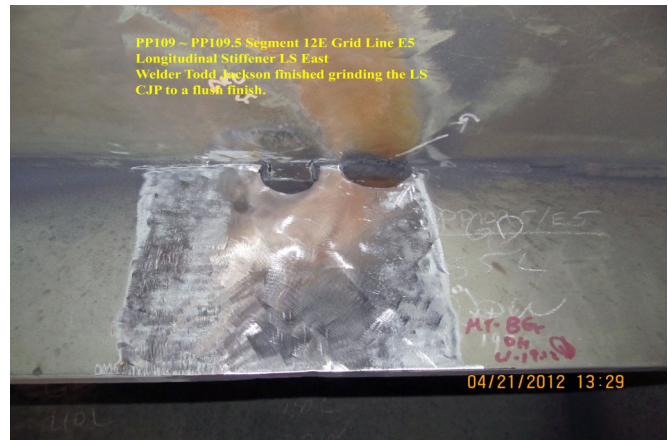
This QA Inspector observed QC Inspector Steve Jensen verify prior to the start of the repair weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwards verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1010 Revision 1 using E7018 (1/8") diameter electrode.

This QA Inspector observed that the fill and cover pass weld operation of the DAH insert plate at the aforementioned location was in-process at the end of this QA Inspectors' shift.

Segment 12E between PP109 and PP109.5 E2 Line - Deck Access Hole:

This QA Inspector observed ABF welder Eddie Brown (Welder ID 9331) performing the air-carbon-arc gouge and grinding operation for the purpose of removing the backing bar from the (bottom side) of the complete-joint penetration groove weld and grinding to sound metal prior to performing the SMAW process in the (4G) overhead weld operation on the Deck Access Hole (DAH) insert plate welded to the Deck "A" plate between panel point PP109 and PP109.5 along Grid Line E2.

This QA Inspector observed that the grinding operation from the (bottom side) of the DAH insert plate CJP groove weld at the aforementioned location was in-process at the end of this QA Inspectors' shift.



Summary of Conversations:

Only general conversations between this QAI and QC on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Peterson, Art

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer